



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3121-143
Job Sheet 190227



Part No: D3121-143

Job Qty: 4 pcs

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/6/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:Pick:A 04.02.18 New issue KJ/DS IPP Rev:B ECN 1060 07-11-12 DD verified by:EC IPP
Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Ship Via:

Bill of Materials

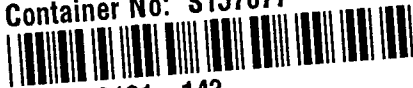
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	4 pcs	3/15/19	3/15/19	0.00	1.47	Bandsaw - 1		
110	HAAS 4 Axis - B4B	4 pcs	3/15/19	3/15/19	0.41	0.00	HAAS - 1 - B4B		
	3x S045230 1x2.0						HAAS - 2 - B4B		
	1x S120118 1.2500x2.0						HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs	3/15/19	3/15/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		

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Container No: S157077



Part: D3121 - 143

Job No: 190227

Serial No/Batch: S157077

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/27/19

130 QC 8	4 pcs	3/15/19	0.00 0.00	QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
140 Small Fab - 2 - B4B	4 pcs	3/15/19	0.00 0.18	QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				Small Fab - 1 - B4B	
150 QC 5	4 pcs	3/15/19	0.00 0.00	Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
160 Packaging 3-1 - Stock - B4B	4 pcs	3/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	

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m.m

mk 19/03/05

DAS
36
9-89

DAS
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9-89

MAR 07 2019

					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	54018 87 MAR 13 2019
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
170 QC 21 - SA	4 pcs	3/15/19	0.00 0.00		QC 21 - SA - 21	MAR 13 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Bandsaw - Cut blanks: (1.250" x 2.000") 4.425" long
 Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine D3121-113 as per Folio FA330 and Dwg D3121
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Small Fab - Assemble D3121-143 as per Dwg D3121.
 150 - QC5- Inspect part completeness to step on W/O)
 160 - Identify as per dwg & Stock Location: _____
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	
M17-4-B1.250X2.000	17-4 SS Bar 1.250 x 2.00	1.4720 ft (.368 ea)	100-Bandsaw - 1	1.00X2.00 Container
D3121-21	Bolt	8 pcs (2 ea)	140-Small Fab - 2 - B4B	5045230 3/20/18 1.25X2.00
D3121-241	Bearing Assembly	8 pcs (2 ea)	140-Small Fab - 2 - B4B	5152233 5159856

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M17-4-B1.250X2.000	1	6	0
140-Small Fab - 2 - B4B	D3121-21	8	5	0
	D3121-241	8	38	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD	Work Order:	190227
Description: Bracket	Part Number:	D3121-113
Inspection Dwg: D3121 Rev: E		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	.082	✓		Vernier	
0.300	+/-0.010	.301	✓		Vernier	
R0.375	+/-0.010	R.375 ok	✓		Gabarit	
1.54	+/-0.030	1.542	✓		high gage	
0.350	+/-0.010	.350	✓		high gage	
R0.25	+/-0.030	R.250 ok	✓		Gabarit	
Ø0.392	+0.002/-0.000	.393	✓		micrometre	
Ø0.201	+/-0.010	.200	✓		pin gauge	
2.540	+/-0.010	2.538	✓		Vernier	
1.590	+/-0.010	1.588	✓		Vernier	
0.160	+/-0.010	.159	✓		Vernier	
0.400	+/-0.010	.398	✓		Vernier	
1.220	+/-0.010	1.219	✓		Vernier	
1.600	+/-0.010	1.606	✓		Vernier	
3.80	+/-0.030	3.798	✓		Vernier	
1.800	+/-0.010	1.805	✓		Vernier	
R0.50	+/-0.030	R.500	✓		Gabarit	
0.130	+/-0.010	.131	✓		micrometre	
3.41	+/-0.030	3.405	✓		Vernier	
3.65	+/-0.030	3.640	✓		Vernier	
2.24	+/-0.030	2.215	✓		Vernier	
45°	+/-0.1°	45°	✓		Gabarit	
R0.25	+/-0.030	R.250 ok	✓		Gabarit	
3.97	+/-0.030	3.972	✓		Vernier	
R0.38	+/-0.030	R.380	✓		Gabarit	
Ø0.392	+0.002/-0.000	.393	✓		micrometre	
Ø0.201	+/-0.010	.2018	✓		pin gauge	
0.268	+/-0.010	.265	✓			
R0.260	+/-0.010	R.260	✓		Gabarit	
0.080	+/-0.010	.082	✓		Vernier	
0.300	+/-0.010	.301	✓		Vernier	
0.381	+/-0.010	.385	✓		Vernier	
0.201	+/-0.010	.202	✓		Vernier	
0.580	+/-0.010	.585	✓		Vernier	
0.400	+/-0.010	.399	✓		Vernier	

